

Work Order ID 54772

December 21, 2009 10:11:48 AM

Page 1

Item ID: D3564-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearshoe

Start Date: 12/21/09 Start Qty: 16.00

Cust Item ID:

Required Date: 12/31/09 Req'd Qty: 16.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ☐ Dwg Rev: 0 ☐ Prog Rev: 0 ☐ 2-
Deburr if necessary

HB 10-1-4

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 10-1-4

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S 10/01/09

(16) 9/

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54772

December 21, 2009 10:11:49 AM



Page 2

Item ID: D3564-5

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Setup Start



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Item Name: Wearshoe

Start Date: 12/21/09 Start Qty: 16.00



Cust Item ID:

Required Date: 12/31/09 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Deburr if necessary ☐ Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 ☐ Form Joggle as per Dwg D3564 on brake using Jig DT8157

SB 10/01/13 EP 10/01/13 (16)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Ensure joggle as per dwg D3429

=> 8 10/01/13

(X16)

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:00AM OVEN TEMPERATURE: 320°F
FINISH TIME: 10:30am

=> 11 10-01-13

(X16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54772

December 21, 2009 10:11:49 AM



Page 3

Item ID: D3564-5

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 12/21/09 Start Qty: 16.00



Cust Item ID:

Required Date: 12/31/09 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

BR 10-01-13

(16)



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: FR-19

0.00

ul 10-01-13

(16) Ø



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/14 JF
mf 10-1-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 21, 2009 10:11:48 AM

Page 1

Work Order ID: 54772

Parent Item: D3564-5

Parent Item Name: Wearshoe

Comments:

Start Date: 12/21/09

Required Date: 12/31/09

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	370.2779	25.2632			



304/316 Sheet .063



B 10-1-4

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

370.2778737

106860

8.0295

111924

25.1689737

112442

29.8899

113295

307.1895

113295

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 54772
Description: Wearshoe		Part Number: D3564-5
Inspection Dwg: D3564	Rev: D	Page 1 of 1

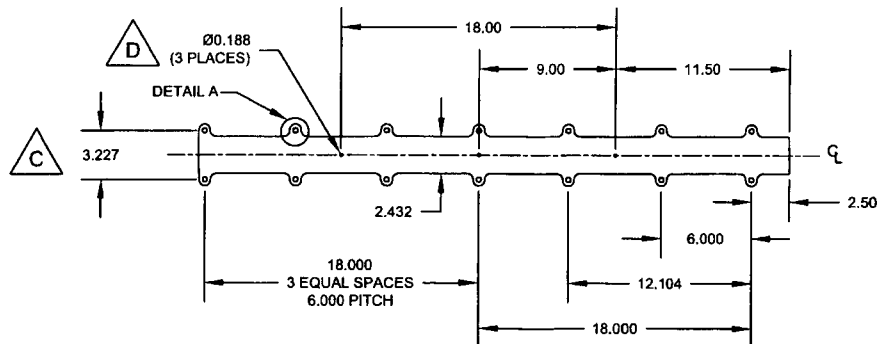
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

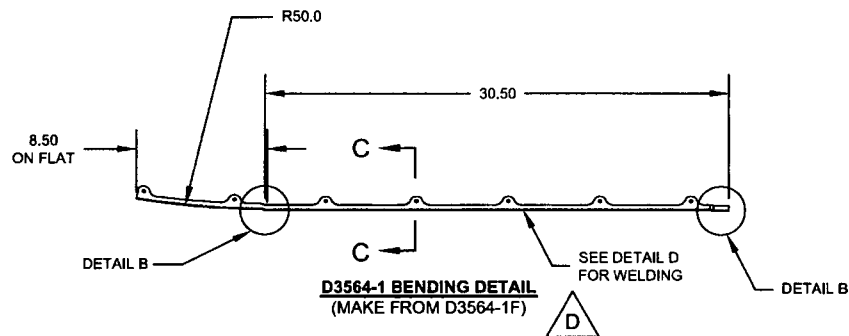
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
43.50	+/-0.030	43.50	✓			
6.75	+/-0.030	6.75	✓			
10.00	+/-0.030	10.00	✓			
20.00	+/-0.030	20.00	✓			
30.00	+/-0.030	30.00	✓			
2.50	+/-0.030	2.501	✓			
3.227	+/-0.010	3.225	✓			
38.500	+/-0.010	38.500	✓			
5.500	+/-0.010	5.498	✓			
2.50	+/-0.030	2.503	✓			
2.432	+/-0.010	2.438	✓			
0.300 x 0.300	+/-0.010	303 x 302	✓			
Ø0.188	+0.005/-0.001	190	✓			
R0.375	+/-0.010	375	✓			
0.063	+/-0.010	060	✓			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-1-4	Date: 10/01/04	Date:	N/A

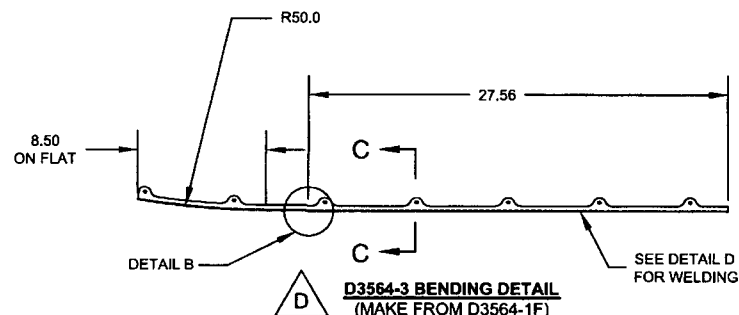
Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	DD



D3564-1F FLAT PATTERN



**D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)**



**D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)**

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

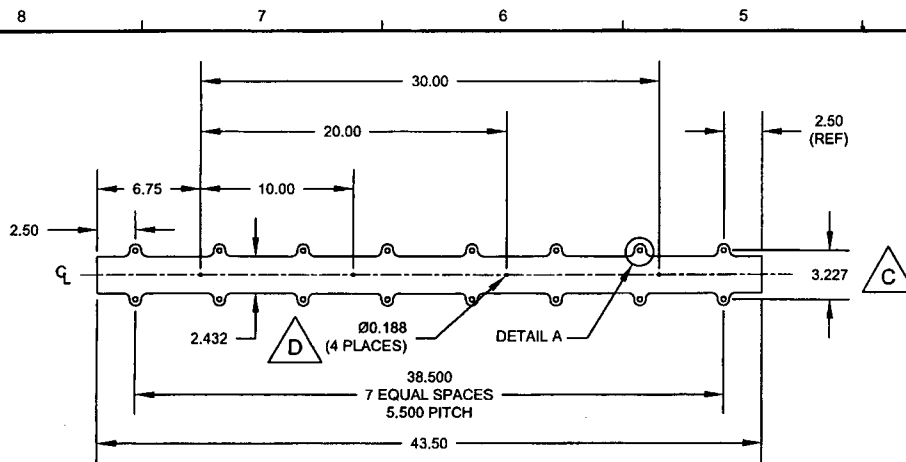
D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE		CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A		PH	07.04.17
B	ADD AMS 5513 AND AMS 5524		PH	07.03.20
A	NEW ISSUE		PH	06.12.18
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	CB			
CHECKED	PH	DRAWING NO.	REV. D	
MFG. APPR.	PH	D3564	SHEET 1 OF 3	
APPROVED	PH	TITLE	SCALE	
DE APPR.	PH	WEARSHOE	1:8	
DATE	07.08.21			

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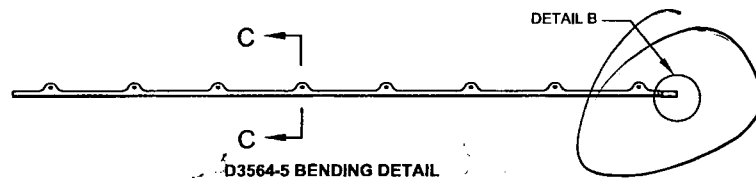
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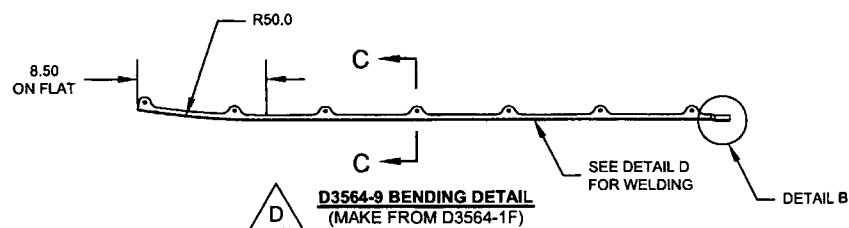
07.09.04



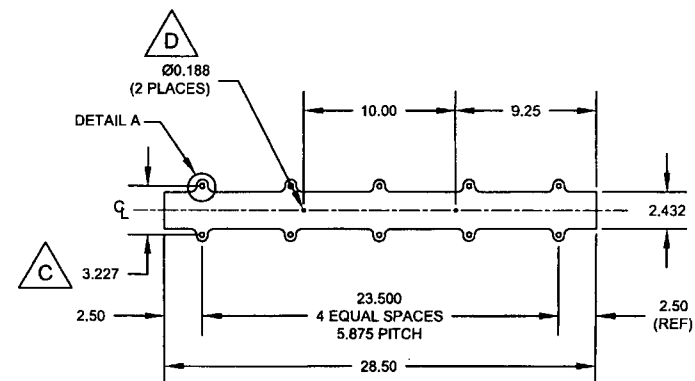
D3564-5F FLAT PATTERN



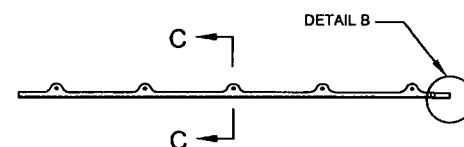
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



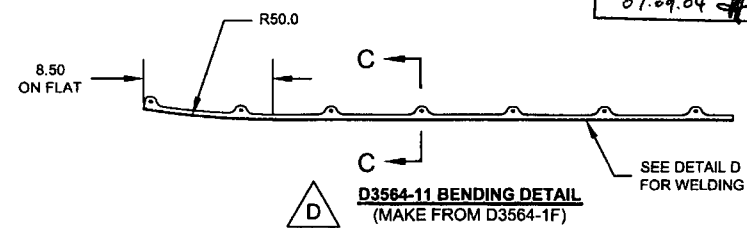
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)

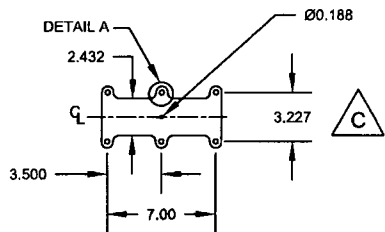


D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

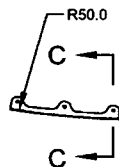
RELEASED
07.09.04

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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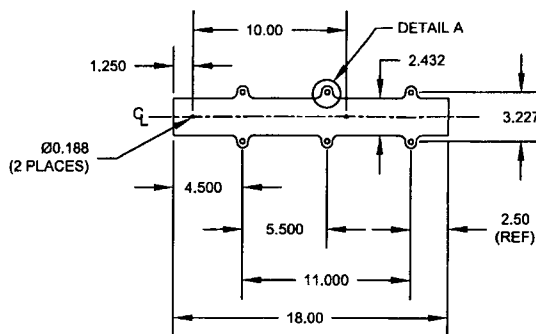
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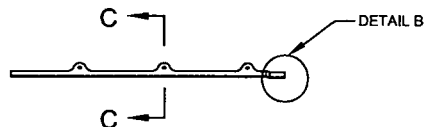
D3564-13F FLAT PATTERN



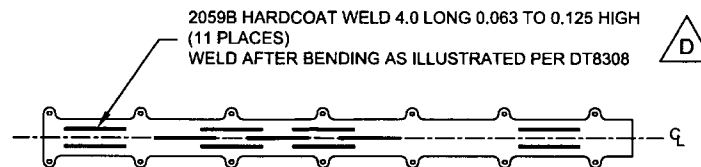
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



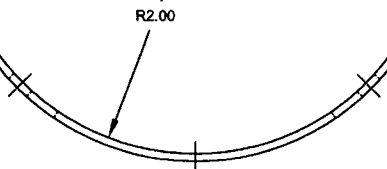
D3564-15F FLAT PATTERN



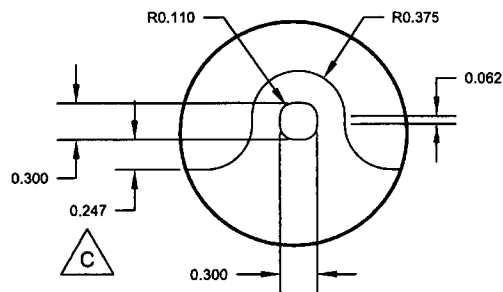
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



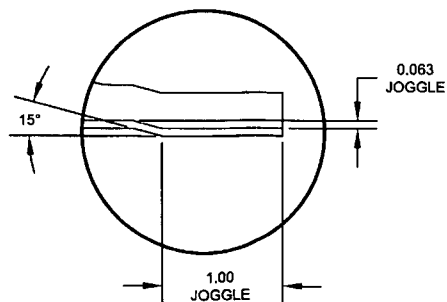
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
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07.09.04

54772